Tuesday, 12/20/2005 9:48:40 AM

User

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 23136A

Estimate Number

: 11273

P.O. Number

This Issue

. NIA

: 12/20/2005 Prsht Rev.

First Issue

: NC

: NIA : NIA

Type : LARGE FAB ASSY

: SEE COMMENT BELOW

Part Number

Drawing Name

: D2252041

: N/A

Drawing Number

: UNDER REVIEW

: 206L BASKET BASE

Project Number Drawing Revision

: E : N/A

Material **Due Date**

: 1/30/2006

Qty:

1 Um:

Each

Written By

Comment

Previous Run

Checked & Approved By

COMMENT : Est Rev:I

Revised as per Rev E 05-12-06 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D31661

Basket Hoop

5.0000 Each(s)

5.0000 Each(s)/Unit Total:

Pick:

Qty

5

Part#

D3166-1

Description Batch

qooH

B 24880

2.0

M304TS0750W065

304 SQ Tube.75x.75x.065W

Comment: Qty.:

Comment: Qty.:

25.0000 f(s)/Unit Total:

25.0000 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M19447

3.0

LARGE FABRICATION RESOURCE 1







1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 5 D2235-1 From D3166-1



2- Cut Ribs as per Dwg D2252

3-Drill hole in D2252-1as per Dwg D2252

06/01/20

4-Deburr & Remove all Markings from Material

4.0

D22531

Pick:

Lug





2.0000 Each(s)

Comment: Qty.:

2.0000 Each(s)/Unit Total:

Description

Batch

2 D2253

Qty Part Number

Gusset

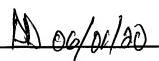
Dart Aerospace Ltd

W/O:		WORK ORDER CHAN	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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- 10 - •											
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _					
			QA: I	N/C Close	d:	_ Date: _					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B					A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
4											
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NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:48:40 AM Linda Lacelle User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: 206L BASKET BASE Job Number: 23136A Part Number: D2252041 Job Number: Seq. #: **Machine Or Operation: Description:** 5.0 D23273 Spacer Bushing Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: **Qty Part Number** Description Batch 1 D2327-3 Bushing D2581 Mounting Bracket 6.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: **Qty Part Number** Description Batch 4 D2581 Mounting Chanel _ 7.0 D2254 Gusset for D206bskt Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: **Qty Part Number** Description Batch 2 D2254 823421 8.0 D22323 Basket Hinge Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: **Qty Part Number** Description Batch 2 D2232-3 HINGE 9.0 D22531 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: **Qty Part Number** Description Batch 2 D2353-1 B12413 LUG M304EX07516F 10.0 Expanded Metal Flat Stai Comment: Qty.: 33.6000 sf(s)/Unit Total: 33.6000 sf(s)



Pick:

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W/O:			WORK ORDER CHANGES								
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA	: Date:
			QA: N/C Closed	: Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	T	Description of NC	Corrective Action Section B			Verification	A				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	tion Sign & Date		Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

Tuesday, 12/20/2005 9:48:40 AM Date: User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: 206L BASKET BASE Job Number: 23136A Part Number: D2252041 Job Number: Seq. #: Description: **Machine Or Operation:** LARGE FABRICATION RESOURCE 1 LARGE FAB 1 11.0 Comment: LARGE **FABRICATION RESOURCE 1** 1-Weld as per Dwg D2252using Welding Table and corner JigDeburr as required A/R SS ROD Batch: M9174 WELD INSPECTION 12.0 QC5/9 060120 **Comment: WELD INSPECTION** 13.0 POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 14.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 15.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA 16.0 DOCUMENT CONTROL Comment: DOCUMENT CONTROL 5 yr 06/01/23 Inspection Level 21 Job Completion

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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANG	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:	PAR #:	_ Fault Category:		NCR: Yes No	DQA:	Date: <u>එ/ෙ/ </u>
			**	QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	T	Description of NC	Corrective Action Section B					A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries